

Date: Wednesday, 10/11/2006 11:12:22 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: PLACARD
Job Number	: 28924		
Estimate Number	: 11149		
P.O. Number	: N/A	Part Number	: D32141
This Issue	: 10/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3214 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26148	Drawing Revision	: B
Written By	: <i>[Signature]</i>	Material	: N/A
Checked & Approved By	: <i>[Signature]</i> 06/10/11	Due Date	: 10/20/2006
Comment	: Est. A04.04.15 New issue KJ/RF Est Rev:B Now 6061-T6 06-06-23 JLM	Qty:	20
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080 <i>M6052H32</i>	6061-T6 .080 Sheet 
		Comment: Qty.: 0.0780 sf(s)/Unit Total : 1.5603 sf(s) 5052-H32 .080 Sheet Material: 6061-T6 0.080" thick (M6061-T6S.080) Identify for D3214-1 Batch: <i>m100947</i>
2.0	SHEAR	SHEAR 
		Comment: SHEAR Cut blanks: 3.70" x 2.70" Drill hole and fillet corner as per Dwg D3214 Deburr Identify as D3214-1 <i>jmF 06/10/26</i> <i>mf 06/10/26</i> <i>mf 06/10/26</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP 
		Comment: INSPECT WORK TO CURRENT STEP <i>SP 06/10/27</i>
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1 <i>a.m 06/10/27</i> <i>20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/11/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:12:22 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLACARD

Job Number: 28924

Part Number: D32141

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 11 02 20

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.14

06/11/03

20

7.0 SMALL FAB 1 Maas 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Engrave text as per Folio FA394 and Dwg D3214

ML 06/11/03

20

8.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/11/03

20

9.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ML 06/11/03 20

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST416

ML 06/11/03 20

11.0 QC21 FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

ML 06/11/09

Job Completion



ML 06/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>FF</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3214	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE PLACARD	SCALE 1:1
A	04.01.27	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**06.06.20 *MM***D3214-1****NOTES**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)  
0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK  
(REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
4.3 WORK ORDER  
NO. *289124*

**Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.